Work Order ID 77488

December-08-11 1:40:28 PM

77488

Item ID: D2535 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Spring

Start Date: 08/12/2011 **Start Qty:** 50.00 *50*

Required Date: 22/12/2011 **Req'd Qty:** 50.00 *50*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** M.C.J **Date:** 11/12/08 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D2535	Revision Nbr: Rev A								
100		0.00							
100	PURCHASING								
Purchasing						CL	11/12/12		50
Purchasing	**Memo**	0.00							
	Issue P/O: 15645 Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging							11/12/12		50
Packaging	**Memo**	0.00							
	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00				counted			
120		0.00				x50			
QC		11/12/22							
Quality Control	**Memo**								
	Check dims to dwg								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 77488
December-08-11 1:40:28 PM

77488

Item ID: D2535
Revision ID:
Item Name: Spring
Start Date: 08/12/2011 **Start Qty:** 50.00 *50*
Required Date: 22/12/2011 **Req'd Qty:** 50.00 *50*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: ST504	0.00							
130									
Packaging	**Memo**	0.00							
Packaging									
						SP 11-12-23			
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	**Memo**	0.00							
Quality Control									
									11/12/28

11-12-23 GD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

December-08-11 1:40:32 PM

Work Order ID: 77488

77488

Parent Item: D2535

D2535

Parent Item Name: Spring

Start Date: 08/12/2011 **Required Date:** 22/12/2011

Start Qty: 50.00 **Required Qty:** 50.00

Comments: IPP A99.04.19New Issue (From hand written IPP)DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2535P		Purchased	No			100	Each	0.0000	1	50			
D2535P Spring									**				

12/12/11 (50)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

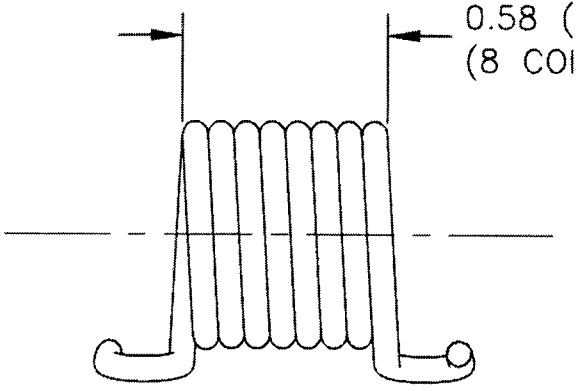
NOTE: Date & initial all entries

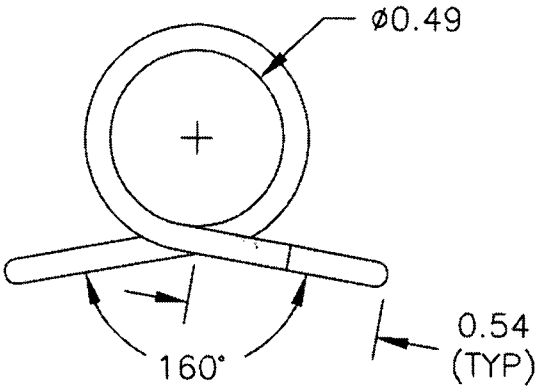
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW	RF		
CHECKED: KE	APPROVED: DM	DRAWING NO.: D2535	REV. A SHEET 1 OF 1
DATE: 99.04.08		TITLE: SPRING SPEC CONTROL	SCALE: 2:1
A	99.04.08	NEW ISSUE	

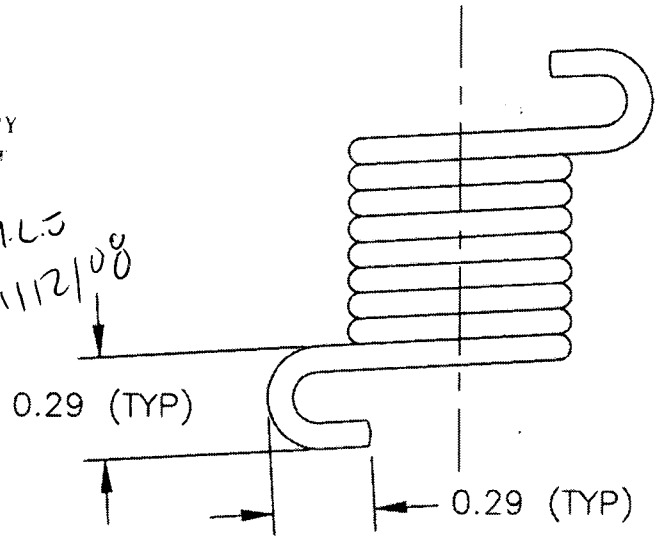
DART

DA COPY ISSUED

RELEASED
99.05.11 KE







SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)
MATERIAL: AISI STAINLESS STEEL ø0.070
POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15645

Purchase Order Date 12/12/11
PO Print Date 12/12/11

Order From : VC-VIC002

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

Contact Name		**Buyer**	Chantal Lavoie
Vendor Phone	866 230 5312	**Requisition Nbr**	
Vendor Fax	866 230 5338	**Tax Resale Nbr**	10127-2607
Vendor Account Nbr		**Terms**	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference / Revision ID / Vendor Part Number	Description / Mfg ID	Req Date / Taxable	Req Qty / Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2535P	Spring	12/23/11 Yes	50.00 Each	FedEx PI collect	$4.5600	$228.00

Special Inst: AS PER DWG D2535 REV. A
B77488

PO Total: **$228.00**

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

Change Nbr: 1 **Change Date:** 12/12/11

VICTORY SPRING
convenient. consistent. correct.

#2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

PACKING SLIP

23812

BILL TO:
Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

SHIP TO:
Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

DATE	ORDER No.		SHIP VIA
Dec 19, 2011	PO15645		FedEx

QUANTITY	DESCRIPTION	UNIT	AMOUNT
50	VIC 1533 D2535P Spring - Torsion Sub 12/21		

GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS				

VICTORY SPRING
convenient. consistent. correct.

2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace	DATE: 12/19/11
PART/DRAWING #: D2535P	PO # PO15645
SPRING DESCRIPTION: Torsion	QUANTITY: 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS302	yes	
Material diameter	0.07	0.072	per previous orders
Coil I.D.	0.490	0.5	
Coil O.D.			
Number of Coils	8 ref	8	
Free Length			
Helix	RHW	yes	
End type	per dwg	yes	
Deburr End			

COMMENTS

8 11/12/22

Mill Certificate attached: yes
Material Heat Number: 35791

Inspected by: *Heidi Burrowes*

VICTORY SPRING
convenient. consistent. correct.

2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

MATERIAL CERTIFICATION

REPORT FOR: Dart Aerospace	DATE: 12/19/11
PART/DRAWING #: D2535P	PO # PO15645
SPRING DESCRIPTION: Torsion Spring	QUANTITY: 50
MATERIAL GRADE: T302 Stainless Steel Wire Spring ASTM-313-03	

PROPERTIES:

Chemical

Carbon:	(C)	0.053
Chromium:	(Cr)	18.210
Copper:	(Cu)	0.410
Manganese:	(Mn)	1.600
Molybdenum:	(Mo)	0.400
Nickel:	(Ni)	9.240
Nitrogen:	(N)	0.030
Phosphorus:	(P)	0.032
Silicon:	(Si)	0.430
Sulphur:	(S)	0.001

S 4/12/12

Physical

Size:	0.072
Tensile:	254,000/261,000
Hardness:	N/A
Heat #	35791

Certified by: *Heidi Burrowes*

Victory Spring Ltd. certifies this to be a true & accurate copy of the original contained in the company records.